

Work Order ID 139172 7

Thursday, December 03, 2015 1:00:01 PM

139172

Page 1

Item ID: PB67-43001-171

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Mounting Plate

Stop ***NS2***

Start Date: 11/16/2015 Start Qty: 170.00

170

Cust Item ID:

Required Date: 12/11/2015 Req'd Qty: 170.00

170

Customer:

Reference:

Approvals: Process Plan: MLJ Date DEC 03 2015 Tooling: _____ Date: _____Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
B67-43001	C

100

100

BAND SAW

0.00

Bandsaw

Memo

0.09

Jeaspa Bandsaw

1- cut as per dwg PB67-43001-171

2- deburr

166ØDAS
20
9-8916-01-27

110

110

CONVENTIONAL MILLING MACHINE

0.00

Mill Conv

Memo

0.17

Conventional Milling Machine

1- drill holes as per dwg PB67-43001-171

166ØDAS
20
9-8916-01-28

120

120

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.03

Quality Control

166ØDAS
20
9-8916-01-28

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :							
Misidentified	☐	Past Due	☐								

Page 2

Thursday, December 03, 2015 1:00:01 PM

Reference:

Run	Start	*NR1*
	Stop	*NR2*

125 QC8- Inspect parts - second check

QC

Memo

Quality Control

130

Small Fab

Small Fab

Small Fab

Memo

1- countersink rivet holes as per dwg PB67-43001

2- rivet nutplate as per dwg PB67-43001-79

140

QC5- Inspect part completeness to step on W/O

OC

Memo

Quality Control

DAS
38
9-89

FEB 01 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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Substation ☐	☐	Process Improvement ☐		☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date ☐	☐	Manufacturing Process ☐		OTHER : _____							
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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

Picklist Print

Thursday, December 03, 2015 1:00:04 PM

Work Order ID: 139172

139172

Parent Item: PB67-43001-171

PR67-43001-171

Parent Item Name: Mounting Plate

Start Date: 11/16/2015

Required Date: 12/11/2015

Start Qty: 170.00

Required Qty: 170.00

Comments: IPP Rev:A 08-07-17 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6A1.000W.125		Purchased	No			100	f	36.9733	0.0833	14.90632			DAS
M6061T6A1 000W 125										**	116.250'		20 9-89 16-01-27
6061T6 ANGLE 1.00 x 1.00 x .125W /													

Location	Loc Qty	Loc Code
MAT051	36.97332	
122081	0.2891	
m130524 /	36.68422	

MS20426AD3-4		Purchased	No			130	Each	3,268.000	2	340			
MS20426AD3-4										**	16.250'		
RIVET													

Location	Loc Qty	Loc Code
GA	3109	
m131697 -	3109	
ST312	159	
m127432	159	

MS21075L3	MS21075L3N	Purchased	No			130	Each	70.0000	1	170			
MS21075L3										**	16.02/01		DAS 36 9-89
Nut Plate													

Location	Loc Qty	Loc Code
ST298	70	
M131153	70	

LD M128429
166x

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Past Expiry Date	☐	Manufacturing Process	☐	OTHER :							
Misidentified	☐	Past Due	☐								

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0.13
REFRADIUS
OPTIONAL1.00
TYP, REF
 $\triangle C \text{ } \phi 0.098 \text{ THRU}$
 $\phi 0.167 \times 100^\circ \text{ CSK}$
 2PL

 $\triangle C$ 0.500
 $\triangle C$ 0.250

 $\phi 0.194$
 THRU

0.500

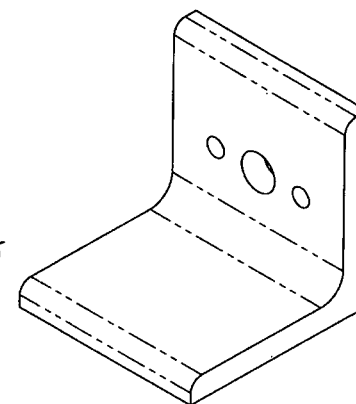
0.500

1.00

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T6510/T6510/T6511) ALUMINUM ANGLE
PER AMS-QQ-A-200/8
REF. DART SPEC. M6061T6A1.00XW125
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 139172-MW
 15-12-03

**B67-43001-171 MOUNTING PLATE**

RELEASED
 2009-09-24
 MD

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO PAGE 27 OF PREMIER AVIATION DRAWING No. B67-43001; ADDED CSKED $\phi 0.098$ THRU HOLES. REASON: SEE PAR#09-011.		MB	09.02.19
REV.	DESCRIPTION		BY	DATE
DESIGN	R/W	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. B67-43001-171 TITLE MOUNTING PLATE		
DRAWN				
CHECKED	ASS			
MFG. APPR.				
APPROVED		REV. C SHEET 1 OF 1		
DE APPR.	N/A	SCALE NTS		
DATE	09.02.19		COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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